

Work Order ID 117572

April-28-14 8:08:28 AM

117572

Page 1

Item ID: D4712-043

Revision ID:

Item Name: Bracket Assembly

Start Date: 4/28/14 Start Qty: 4.00

Required Date: 4/29/14 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: 4-28-14 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4712	C								
100	Pick Kit	0.00							
100	FLOW WATER JET								
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

D4712-043
B117572

4

4

DAS
27
9-89

4/4/29

DAS
36
9-89

4/4/29

4x

4x

4

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Item ID: D4712-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 4/28/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/29/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST/20</u>	0.00							
130									
Packaging	Memo	0.00				4X	DAS 28 9-89	APR 29 2014	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/4/30 *[Signature]*
 14.4.29

Picklist Print

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Page 1

Work Order ID: 117572

117572

Parent Item: D4712-043

D4712-043

Parent Item Name: Bracket Assembly

Start Date: 4/28/14

Required Date: 4/29/14

Start Qty: 4.00

Required Qty: 4.00

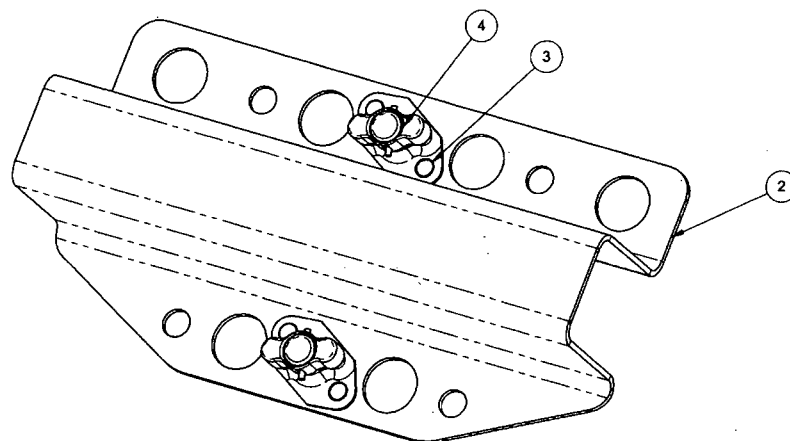
Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4712-3		Manufactured	No			100	Each	3.0000	1	4			DAS 36 9-89
D4712-3									**			14/04/29	
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
					111164			3					
MS20426AD3-2		Purchased	No			100	Each	18,153.00	4	16			DAS 36 9-89
MS20426AD3-2									**			14/04/29	
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz				18153					
					1173			8873					
					13276			9280					
2350-18-C3Y		Purchased	No			100	Each	661.0000	2	8			DAS 36 9-89
2350-18-C3Y									**			14/04/29	
Rigid Receptacle													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST395				661					
					M127987			6					
					M128047			655					
										8			

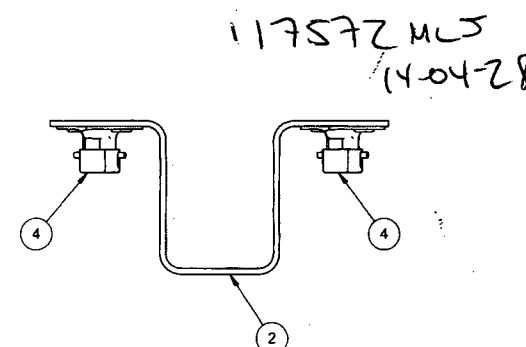
B115134 (40)

M128754 (16x)

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4712-043	BRACKET ASSEMBLY
2	1	D4712-3	BRACKET
3	4	MS20426AD3-2	RIVET
4	2	2350-18-C3Y	RIGID RECEPTACLE



D4712-043 BRACKET ASSEMBLY

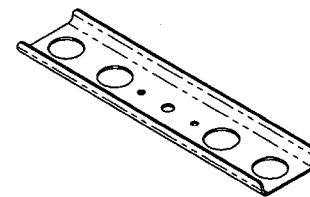
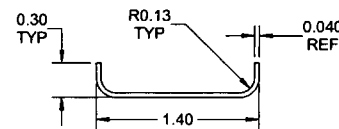
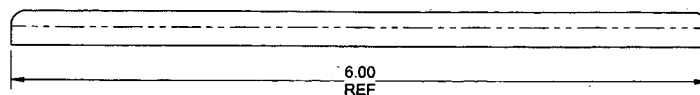


RELEASED
R 2013-12-23
ASS ECN 13-705

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

C	Ø 0.129 WAS Ø 0.098 (ZN C4-3)	RF	13.09.11
B	REMOVED -041/-5; REMOVE CSK ON D4712-1F (ZN D4-3); Ø 0.221 WAS Ø 0.500 (ZN B4-3); REVISE D4712-3/-043 (ZN B4-4, B4-5)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4712 REV. C SHEET 1 OF 5 TITLE SUPPORT BRACKET ASSY SCALE NTS <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED	PC		
MFG. APPR.	DS		
APPROVED	SS		
DE APPR.	SS		
DATE	13.09.11		



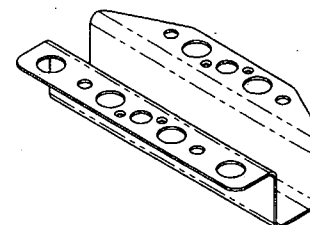
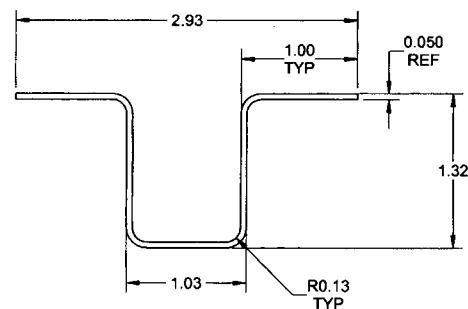
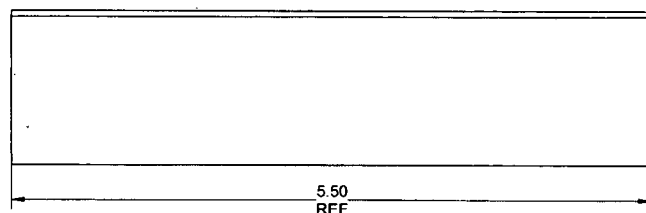
D4712-1 BRACKET

RELEASED
2013-12-23
135

NOTES:

- 1) MATERIAL: MAKE FROM D4712-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DS	D4712	SHEET 2 OF 5
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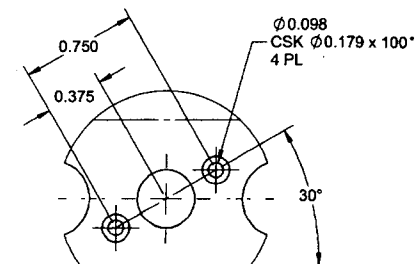
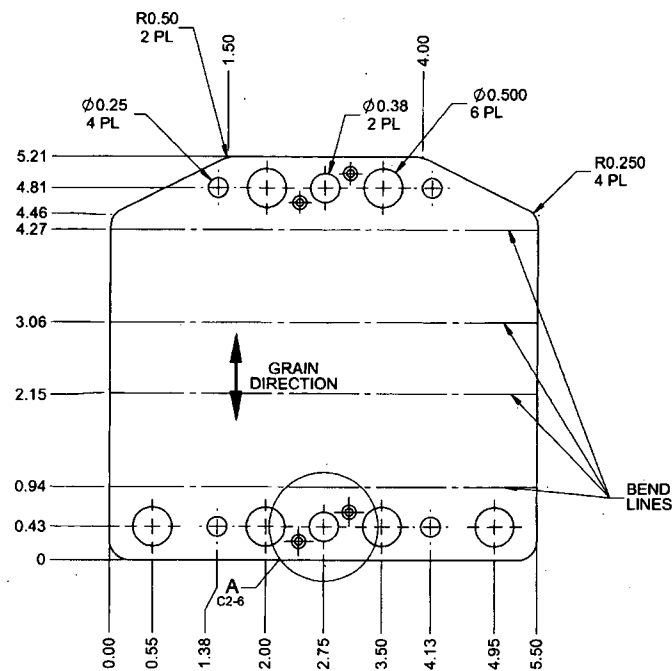
D4712-3 BRACKET

RELEASED
2013-12-23
ASS

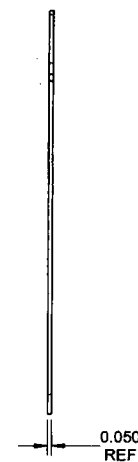
NOTES:

- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

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MFG. APPR.	DS	D4712	SHEET 4 OF 5
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DETAIL A B6-6
2 PL D5-6



D4712-3F FLAT PATTERN BRACKET

RELEASED
2013-12-23
1/25

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

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APPROVED	NS	TITLE	SCALE
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